Annexure "C"

Specifications for GI ERW Tubes and CR ERW MS Round Pipes

Annexure "C"

I) GI ERW Tubes: As per IS 4923 : 2017

A) Chemical Composition:

i) Sulphur : 0.04 % Maximum.

ii) Phosphorus : 0.04 % Maximum.

B) Tensile properties:

i) Grade: YSt 240

ii) Tensile Strength : 410 MPa Minimum

iii) Yield Stress : 240 MPa Minimum

iv) Elongation : 10 % Minimum (For 25.4mm and under)
15 % Minimum (Over 25.4mm)

C) Tolerances:

i) Thickness : +/- 10 %

ii) Outside dimensions of sides: +/- 1 % with a minimum of +/- 0.5 mm.

iii) Squareness of corner: 90^0 +/- 2^0

D) Designation: Cold formed.

E) Manufacturing process : ERW

II) CR ERW MS Round Pipes: As per IS 3074 : 2013.

A) Chemical Composition:

i) Sulphur : 0.04 % Maximum.

ii) Phosphorus : 0.04 % Maximum.

iii) Carbon : 0.12 % Maximum

iv) Manganese : 0.60 % Maximum

B) Tensile properties:

i) Tensile strength : 310 MPa minimum (32 Kgf / mm^2)

ii) Yield stress : 160 MPa minimum (17 Kgf / mm^2)

iii) Crushing test : 50% minimum

iv) Condition : Annealed / Normalized

C) Tolerance : As per IS 5429 : 1979

D) Designation : CEW-1